

Ship NOV. 25

Work Order ID 153340

153340

Page 1

Wednesday, November 16, 2016 1:40:01 PM

Item ID: D350-567-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Window, Large
 Start Date: 11/16/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/24/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 16-11-16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-567-023		CHG003						
110	Packaging	0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC								
Quality Control	Memo	0.00							

DAS
6
9-89

NOV 16 2016

hskl 21
9-89

16-11-16

1x

DAS
28
9-89

NOV 22 2016

1x

NOV 16 2016

DAS
26
9-89
DAS
27
9-89

1x

DAS
28
9-89

NOV 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 153340

Wednesday, November 16, 2016 1:40:01 PM

153340

Page 2

Item ID: D350-567-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Window, Large

Start Date: 11/16/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-023								
	Location: _____								
	PPP Rev: <u>PPP 153339</u>								
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1x **DAS 27** **DAS 28** NOV 22 2016
9-89 9-89

DAS 21 NOV 22 2016
9-89

DAS 21 NOV 22 2016
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																					

Picklist Print

Page 1

Wednesday, November 16, 2016 1:40:08 PM

Work Order ID: 153340

153340

Parent Item: D350-567-023

D350-567-023

Parent Item Name: Replacement Window, Large

Start Date: 11/16/2016

Required Date: 11/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-06-07 JLM
 IPP Rev:B 08-10-07 as per revD DD verified by: IPP REV:C
 13.10.15 AS PER IIN REV.E DD VERF:JLM IPP REV:D 16.04.25
 as per chg003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20426AD3-5

Purchased

No

Each

3,794.000

18

18

MS20426AD3-5

Rivet

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

2382

4533

2382

ST312

1412

4533

1412

NOV 16 2016

DAS
26
9-89
2
9

212-12

Purchased

No

110

Each

67.0000

9

9

212-12

Receptacles

DAS
28
9-89

Location

Loc Qty

Loc Code

ST577

67

M135058

17

M135774

50

NOV 16 2016

DAS
26
9-89
2
9

2600-6

Purchased

No

110

Each

126.0000

9

9

2600-6

Camlock Stud

DAS
28
9-89

Location

Loc Qty

Loc Code

Sr569

48

M133064

48

ST580

78

M135774

28

M135884

50

NOV 16 2016

DAS
26
9-89
2
9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause				FAULT CATEGORY							
Environment ☐			No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐			Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐			Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐			Manufacturing Process ☐	OTHER : _____							
Misidentified ☐			Past Due ☐								

Picklist Print

Page 2

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Work Order ID: 153340

153340

Parent Item: D350-567-023

D350-567-023

Parent Item Name: Replacement Window, Large

Start Date: 11/16/2016

Required Date: 11/24/2016

Start Qty: 1.00

Required Qty: 1.00

2600-LW Purchased No 110 Each 90.0000 9 9

2600-LW

Washer, Camlock Retaining

DAS
28
9-89

Location Loc Qty Loc Code

ST580 90
m135058 90

**

DAS
26
9-89

NOV 16 2016

AN526C832R9 Purchased No 110 Each 285.0000 22 22

AN526C832R9

Screw

DAS
28
9-89

Location Loc Qty Loc Code

over006 200
M134962 200
ST327 85
M135766 85

**

DAS
26
9-89

NOV 16 2016

D2463 Manufactured No 110 f 515.8396 6.25 6.578947

D2463

1/2" Seal (\$ per foot)

DAS
28
9-89

Location Loc Qty Loc Code

ST409 515.8395791
140013 15.8395791
148875 500

**

DAS
26
9-89

NOV 16 2016

(D2463-075) Cut (1) at 75.00" as per dwg ***per kit***

D2942 Manufactured No 110 Each 4.0000 1 1

D2942

Replacement Window For -025

DAS
28
9-89

Location Loc Qty Loc Code

ST430 4
144093 4

**

DAS
26
9-89

NOV 16 2016

Wednesday, November 16, 2016 1:40:08 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

Page 3

Wednesday, November 16, 2016 1:40:08 PM

Work Order ID: 153340

153340

Parent Item: D350-567-023

D350-567-023

Parent Item Name: Replacement Window, Large

Start Date: 11/16/2016

Required Date: 11/24/2016

Start Qty: 1.00

Required Qty: 1.00

DT8439 Manufactured Yes

110 Each 0.0000 1 1

DT8439

TEMPLATE

FG-778150-550-ROL

Purchased No

110 sf 1,131.166 18 24

***FG-778150-550-ROL ***

7781 9 oz Glass 50" x 125 yd

Location

Loc Qty

Loc Code

CA2

1131.166712

M127701

4.00004485

M134550

1127.16667

2 Square Yards

MS21042L08

Purchased No

110 Each 940.0000 22 22

MS21042L08

Nut

Location

Loc Qty

Loc Code

GA

50

m135274

50

ST303

890

m135766

90

m135948

300

m135978

500

NAS1149DN832J

Purchased No

110 Each 1,768.000 44 44

NAS1149DN832.J

Washer

Location

Loc Qty

Loc Code

ST264

1768

M135297

1768

Wednesday, November 16, 2016 1:40:08 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET